



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-2BL
Job Sheet 167806-A



Part No: D2933-2BL

Job Qty: 5 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Job Created: 12/12/17

Due Date: 11/24/17

Type: SOLD

Ship Via:

Status: Scheduled

Priority: High

Job Tracking No:

Created By: Linda Lacelle

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC	5 pcs		11/23/17	0.00	0.00	QC8 Machining-1		
140	HandFinish	5 pcs		11/24/17	0.00	0.51	HandFinish1		
150	Outsource	5 pcs		11/24/17			ATE003-VC		
160	QC	5 pcs		11/24/17	0.00	0.00	QC14		
170	Packaging	5 pcs		11/24/17	0.00	0.00	Packaging3-1		
180	QC21-SA	5 Ea		11/24/17	0.00	0.00	QC21		

Part Op 150 - ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO
Descriptions:

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 12/12/17 9:24 AM dart.lacelle.linda

not painted blue

See job #172420

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-2BL
Job Sheet 167806



Plot
(5)

Part No: D2933-2BL

Job Qty: 10 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90.	Start up Operation	10 Ea		11/22/17	0.00	0.00	Start Up Machining		SBL 17/11/25
100	CNC Vertical Machining	10 pcs		11/23/17	0.61	12.94	HAAS 1		SBL 17/11/27
110	Mill Conv	10 pcs		11/23/17	0.00	12.92	Mill Conv 1		SBL 17/11/27
120	QC	10 pcs		11/23/17	0.00	0.00	QC1		SBL 17/11/27
130	QC	10 pcs		11/23/17	0.00	0.00	QC8		D.e 17-18-04
140	HandFinish	10 pcs		11/23/17	0.00	1.03	HandFinish1		
150	SprayPaint	10 pcs		11/24/17	0.00	0.98	Spray Paint		
160	QC	10 pcs		11/24/17	0.00	0.00	QC14		
170	Packaging	10 pcs		11/24/17	0.00	0.00	Packaging3		
180	QC21-SA	10 Ea		11/24/17	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PER PAR16-484***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:21 AM dart.Michaud-Febrille.Victoria

DART AEROSPACE LTD	Work Order: 167806
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.121	SCRAP	.121	SBZ	17/11/20
B	0.100	0.140		.123	.122		.122		
C	0.100	0.140		.120	.115		.118		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.240	1.250		1.250		
F	1.245	1.255		1.250	1.250		1.250		
G	2.495	2.505		2.500	2.500		2.500		
H	0.510	0.515		.515	.514		.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312		.312		
M	0.235	0.240		.237	.238		.238		
N	0.100	0.140		.120	.120	.120	.119		
O	0.540	0.560	.392	.550	.550		.550		
P	0.490	0.510		.500	.500		.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.251	.252		.252		
T	0.100	0.180		.145	.132		.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316		.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.575	1.575		1.575		
Z	0.178	0.198		.188	.188		.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBZ	Audited by: A.E.
Date: 27/11/20	Date: 17-12-04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 167 806
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	#7	#8		
A	0.100	0.140		.120	.120	.119	.121	SBL	17/11/27
B	0.100	0.140		.121	.122	.119	.121		
C	0.100	0.140		.115	.115	.114	.113		
D	0.210	0.230		.221	.121	.221	.221		
E	1.245	1.255		.250	.250	.250	.250		
F	1.245	1.255		.250	.250	.250	.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.513		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		.238	.237	.239	.238		
N	0.100	0.140		.121	.121	.120	.120		
O	0.540	0.560		.550	.550	.548	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.251	.252	.248	.252		
T	0.100	0.180		.138	.140	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.585	1.585	1.585	1.585		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SBL
Date: 17/11/27

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 167806
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	* #11		By	Date
A	0.100	0.140		.120	.120	.120			
B	0.100	0.140		.122	.121	.121			
C	0.100	0.140		.113	.113	.112			
D	0.210	0.230		.221	.221	.221			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.513	.514	.513			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.257	.257	.257			
L	0.312	0.317		.312	.312	.312			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.120	.120	.120			
O	0.540	0.560		.550	.550	.548			
P	0.490	0.510		.500	.500	.500			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.495	2.495	2.495			
S	0.240	0.270		.251	.252	.251			
T	0.100	0.180		.140	.140	.132			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.367	1.367	1.367			
W	0.316	0.321		.316	.316	.316			
X	1.125	1.145		1.135	1.135	1.125			
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.585			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: BBL
Date: 17/11/27

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

* morceau pour remplacer la piece #3 qui est scrap.